

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012563**Date Inspected:** 25-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 11

This QA Inspector observed ZPMC qualified welding personnel identified as 044550. Perform Submerged Arc Welding (SAW) on Web Flange Plate. Joint identified ND1-STSA4-10-119M-1-1A, ND1-STSA4-10-119M-2-1A, ZPMC QC Identified as Fu Wei Min. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4221-B-U3c-S-1.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 066361. Perform Shielded Metal Arc Welding (SMAW) on West tower lift 4, B/C corner joint from Inside, Joint identified WSTL4-2B/L-58B, ZPMC CWI Identified as Lilin. With critical welding repair report, CWR-T-CWR569-Rev.No.1, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)Repair

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 053916, 058026, 046704 Perform

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Shielded Metal Arc Welding (SMAW) on West tower lift 4, B/C corner joint. Joint identified as WSTL4-2B/L-59A, ZPMC QC Identified as Shao Hai Lang. With Temporary welding repair report, WRR-T-WR3071, Y location is 7800, 19080 and 26360mm. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)Repair. For more information see below attached photo.

BAY10

This QA Inspector observed ZPMC qualified welding personnel identified as 050289. Perform Shielded Metal Arc Welding (SMAW) on South tower lift 5, D/E corner joint from Inside, Joint identified SSD1-TL5-1B-F-52A, 11B, ZPMC QC Identified as Wang Hao. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3211-Tc-U4b-1.

This QA Inspector observed during random Visual inspection, ZPMC Magnetic Particle Testing (MT) Inspector perform MT on North Tower lift 4 B/C corner joint gouge out area, MT performed at three locations. Joint identified as NSTL4-3B/L-5A. For more information see below attached photo.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 500364, 040582, 050289. Perform Shielded Metal Arc Welding (SMAW) on North tower lift 4, B/C corner joint from Inside, Joint identified as NSTL4-3B/L-5B, Y location as 29300, 25540, 25150mm. ZPMC QC Identified as Deng Zhi Bing. With critical welding repair report, CWR-T-CWR591, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)Repair.

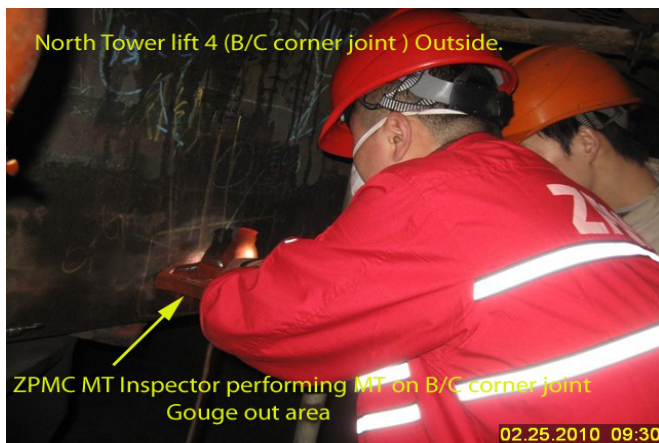
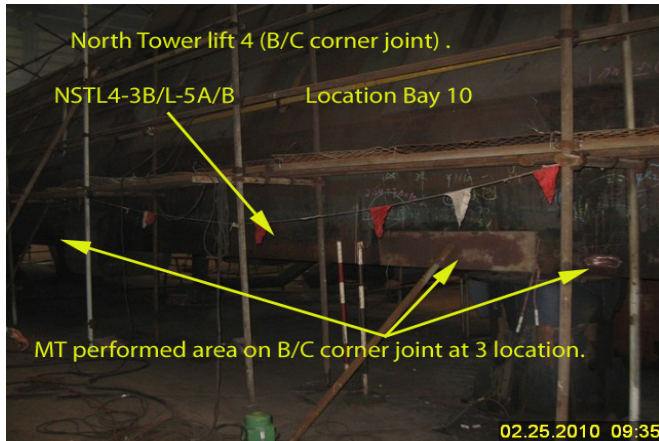
Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 057258. Perform Shielded Metal Arc Welding (SMAW) on North tower lift 4, B/C corner joint, Joint identified as NSTL4-3B/L-5A, Y location as 1630mm. ZPMC CWI Identified as Gang Liang Zhu. With critical welding repair report, CWR-T-CWR591, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G(2F)Repair, For more information see below attached photo.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer